

Date: Thursday, 2/22/2007 2:52:14 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: D119 HELI UTILITY BASKET PRELIM
Job Number	: 30797		
Estimate Number	: 12452		
P.O. Number	: <i>NA</i>	Part Number	: D119756041
This Issue	: 2/22/2007 S.O. No. : <i>NA</i>	Drawing Number	: IIN-D119-756 PG11-12
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>NA</i> Type : LARGE FAB ASSY	Drawing Revision	: <i>BC</i>
Previous Run	: 29556	Material	: <i>NA</i>
Written By	: <i>JA</i>	Due Date	: 3/30/2007
Checked & Approved By	: <i>JA</i> 07.02.23	Qty:	1 Um: <i>1</i> Each
Comment	: Est Rev: A New Issue 06-06-14 JLM Est Rev: B 06.07.26 dwg revB, picklist EC		

*OK AS PER
IW-DWG-756 Rev. C
RELEASED 06.10.23
07.02.23*

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: Photocopy bluefile & type labels per PPPD119-756-041 CHG 001

07.05.04

2.0 30797A BASKET LID ASS'Y (A119)



Comment: Sub-Component BASKET LID ASS'Y (A119) SUB-COMPONENT

B 30797A

3.0 30797B BASKET BASE ASS'Y (A119)



Comment: Sub-Component BASKET BASE ASS'Y (A119) SUB-COMPONENT

B 30797B

4.0 D2022101 Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer

Batch: B 30543

5.0 D2258220 Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Placard

Batch: B 32276

6.0 D2332041 Lid Prop Assembly 6.69"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lid Prop Assembly 6.69"

Batch: B 32572 B 32571 B 32572

CC 7/19/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: D119 HELI UTILITY BASKET PRELIM

Job Number: 30797

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description:

7.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Handle Weldment

Batch: 333939

8.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Spring

Batch: 31484

9.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bushing

Batch: 32574

10.0

D2931

Bumper



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bumper

Batch: 21139

11.0

D35191

placard



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

placard

Batch: 29576

12.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch: 33939 M104603

13.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch: M12140

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: D119 HELI UTILITY BASKET PRELIM

Job Number: 30797

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M102909

Handwritten signature

15.0

AN424A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M101938

Handwritten signature

16.0

AN517A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M104885

Handwritten signature

17.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M105426

Handwritten signature

18.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M1054080

Handwritten signature

19.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: M104106

Handwritten signature

20.0

AN960JD8

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M105516

Handwritten signature 7/10/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Process Sheet

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Drawing Name: D119 HELI UTILITY BASKET PRELIM

Job Number: 30797

Part Number: D119756041

Job Number: 

Seq. #: Machine Or Operation: Description :

21.0 AN9704 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: M105492

h

22.0 MS20600AD4W3 Cherry Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cherry Rivets

Batch: M18071

h

23.0 MS21042L3 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M104625

h

24.0 MS21042L4 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M105054

h

25.0 MS21042L5 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M104812

h

7/10/25

26.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D119-756

M107/10/29

27.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

h 7/10/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Drawing Name: D119 HELI UTILITY BASKET PRELIM

Job Number: 30797

Part Number: D119756041

Job Number:



Seq. #: Machine Or Operation: Description :

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

29.0

D119756011

CLAMP KIT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
CLAMP KIT
Batch: 31579

30.0

D351611

CLEVIS



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
CLEVIS
batch: B 30910

31.0

D35171

STRUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
STRUT
Batch: B 31628 27594

32.0

D3518041

STRUT ASSEMBLY



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
FWD ARM ASSEMBLY
Batch: 31629 7/10/30 SP

33.0

D35201

SPACER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
SPACER B 29578

34.0

D26173

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bushing B 27738

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: D119 HELI UTILITY BASKET PRELIM

Job Number: 30797

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

D26175

Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Spacer 31756

36.0

AN413A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
Batch: M105653

37.0

AN415A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)
Bolt
Batch: M104746

38.0

AN420A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
batch: M16895

39.0

AN510A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
batch: M103962

40.0

AN960JD416

Washer



Comment: Qty.: 40.0000 Each(s)/Unit Total : 40.0000 Each(s)
Washer
Batch: M105726

41.0

AN960JD416L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Washer M105708

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/22/2007 2:52:15 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: D119 HELI UTILITY BASKET PRELIM

Job Number: 30797

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

42.0

AN960JD516L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer *M17618*

43.0

MS21042L4

Nut



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)
Nut
Batch: *M105054*

44.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

45.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D119
Location: _____
PPP Rev: *B*

46.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



C20714101

07.10.31

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

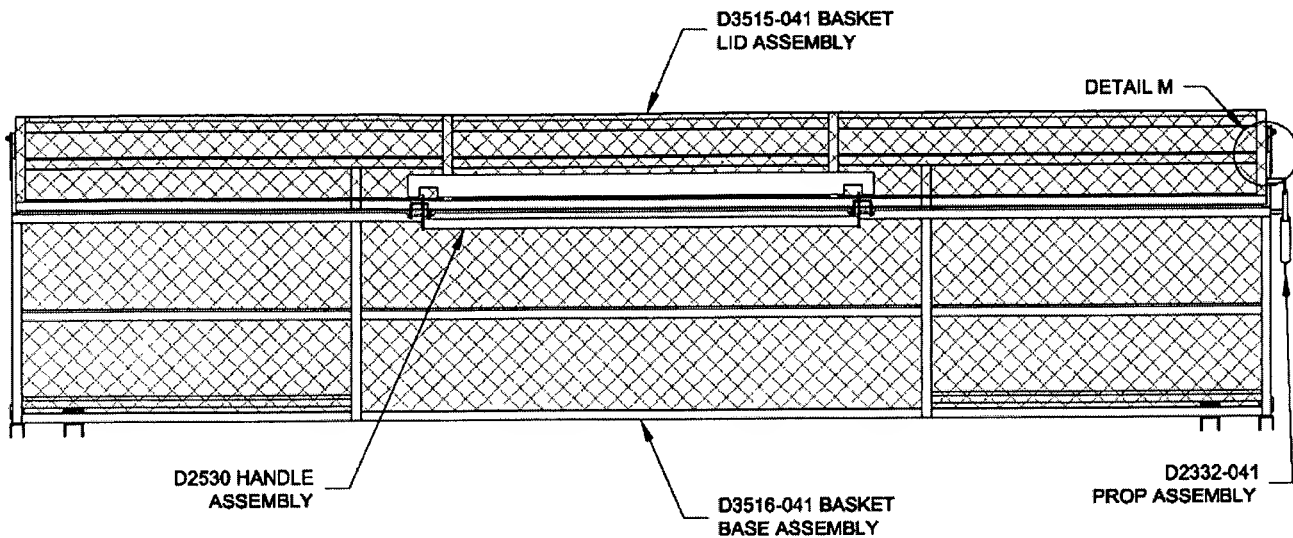
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

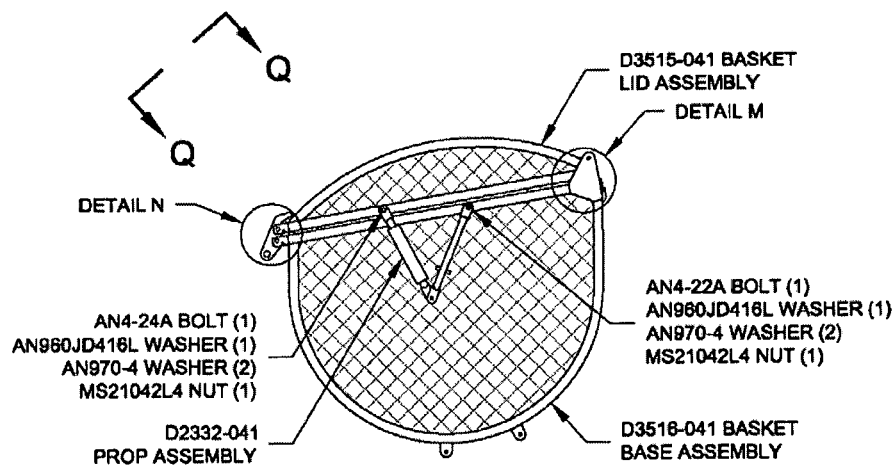
NOTE: Date & initial all entries

4.0 REPLACEMENT PARTS

Figures 4 and 5 list components of the Dart **Heli-Utility-Basket™** which can be replaced if required. Their part numbers are included for reference only, and are normally included with the D3515-041 Basket Lid Assembly or the D3516-041 Basket Base Assembly.



**D119-756-041
HELI-UTILITY-BASKET**



**VIEW C-C:
PROP ARM DETAIL**

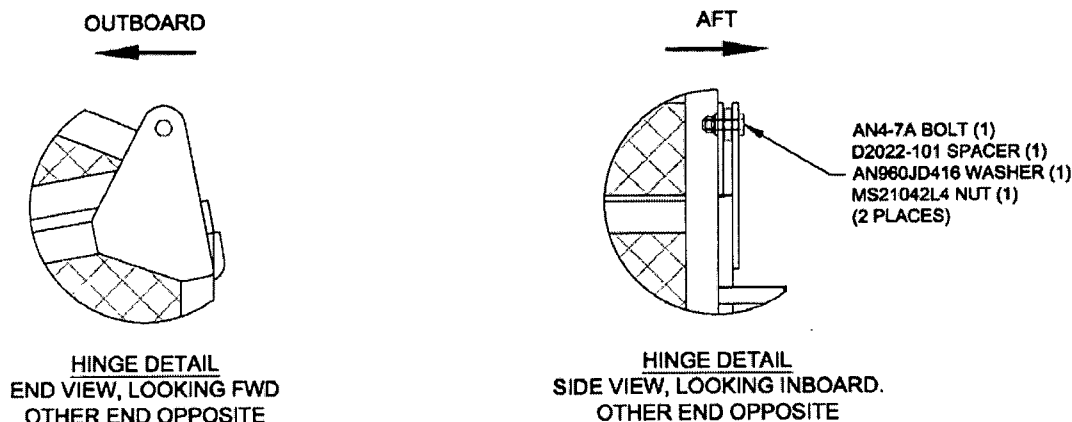
**Figure 4 – Basket Replacement Parts
(D119-756-041 Heli-Utility-Basket™)**

SHOP COPY
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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30797

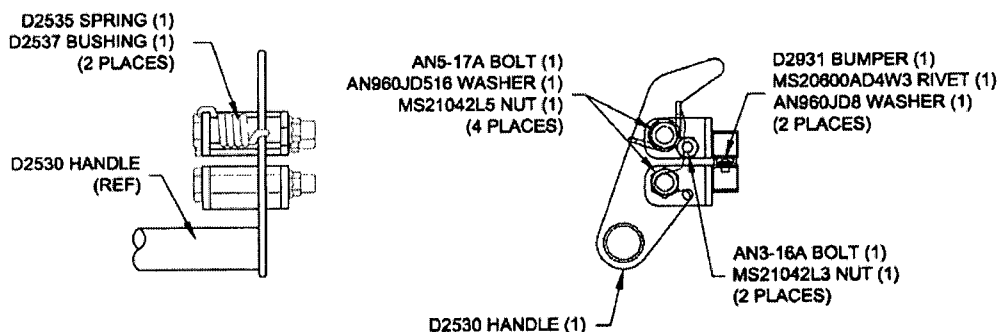
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Revision: **C**

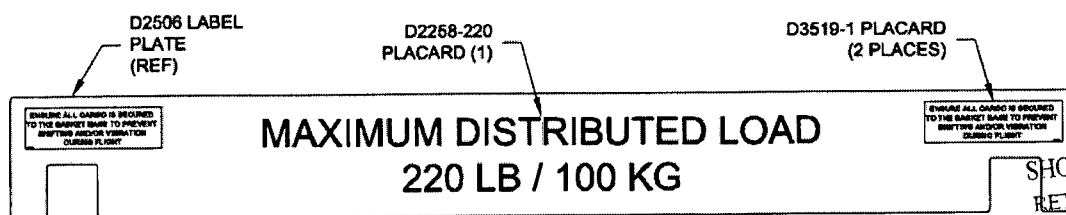
Date: 06.10.23



DETAIL M: HINGE



DETAIL N: HANDLE WELDMENT



VIEW Q-Q: PLACARDS

ONLY PLACARDS AND
LABEL PLATE SHOWN

Figure 5 – Basket Replacement Parts & Placards
(D119-756-041 Heli-Utility-Basket™)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30797

Date: Thursday, 2/22/2007 2:52:29 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET LID ASS'Y (A119)
Job Number	: 30797A	Part Number	: D3515041
Estimate Number	: 12445	Drawing Number	: D3515 PRELIMINARY
P.O. Number	:	Project Number	: N/A
This Issue	: 2/22/2007 S.O. No. :	Drawing Revision	: PRELIMINARY
Prsht Rev.	: NC	Material	:
First Issue	: / / Type : LARGE FAB ASSY	Due Date	: 3/30/2007
Previous Run	: 29556A	Qty:	1 Um: Each
Written By	:		
Checked & Approved By	: <u>07.02.23</u>		
Comment	: EST rev. A 06.06.05 Preliminary EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

10	D22321	Hinge
----	--------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

✓ Basket Hinge
 Batch: B31608

Plot 10.22

20	D31663	Basket Hoop
----	--------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

✓ Basket Hoop
 Batch: B34424

Plot 10.22

30	D23271	Spacer Bushing
----	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

✓ Spacer Bushing
 Batch: B31693

Plot 10.22

40	D2506	Placard
----	-------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

✓ Placard
 Batch: B33449

Plot 10.22

50	D2581	Mounting Bracket
----	-------	------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

✓ Mounting Bracket
 Batch: B34445

Plot 10.22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Date: Thursday, 2/22/2007 2:52:29 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASS'Y (A119)

Job Number: 30797A

Part Number: D3515041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6 0

M304TS0750W065

304 SQ Tube.75x.75x.065W



Comment: Qty.: 43.5750 f(s)/Unit Total : 43.5750 f(s)

AISI 304 SQ Tube.75x.75x.065W

Batch: M105604

7.65' M104980 → 35.925' Pl 07.10.22

7 0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut rib D3515-1 as per dwg D3516

2-Cut rib D3515-3 as per dwg D3516

3-Cut rib D3515-5 as per dwg D3516

4-Cut rib D3515-7 as per dwg D3516

5-Cut Rib (4) D2236 from D3166-3 per dwg D2236

Pl 07.10.22

8 0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3515

Pl 07.10.22

9 0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Pl 07.10.22

10 0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 21.0000 sf(s)/Unit Total : 21.0000 sf(s)

Expanded Metal Flat Stainless steel

Batch: M104218

Pl 07.10.24

11 0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut expanded metal for base as per dwg D3516

2-Cut expanded metal for base ends as per dwg D3516

3-Weld expanded metal to base as per dwg D3516

Pl 07.10.24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASS'Y (A119)

Job Number: 30797A

Part Number: D3515041

Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-10-26 (4)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 07-10-26 (1)

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

m-h 07/10/27

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m-l 07/10/29

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

m-l 07/10/29

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(1)
D 07/10/09

Job Completion



h 07-10-31

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

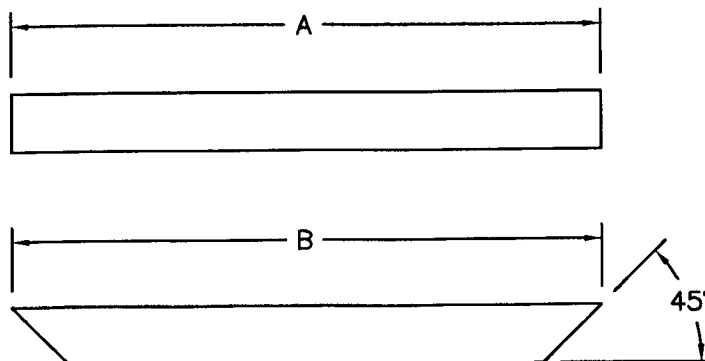
DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3515	REV. A SHEET 1 OF 4
DATE 06.05.05		TITLE BASKET LID ASSEMBLY (A119)	SCALE NTS
A	06.05.05	NEW ISSUE	

RELEASED

06.11.17 H

PARTS LIST FOR D3515-041 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH	LENGTH	DESCRIPTION
		A	B	
D3515-1	2	—	25.50	RIB
D3515-3	2	—	101.30	RIB
D3515-5	6	33.84	—	RIB
D3515-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT

**D3515-1/-3/-5/-7**

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
(REF. DART SPECS. M304TS0.750W.065)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30797A

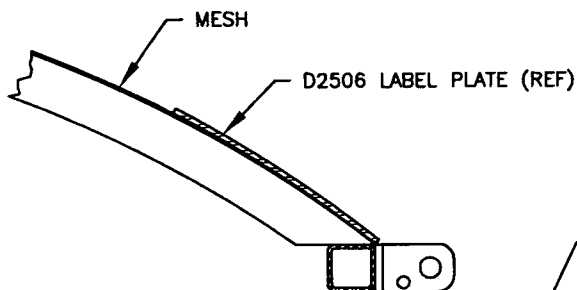
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06.11.07



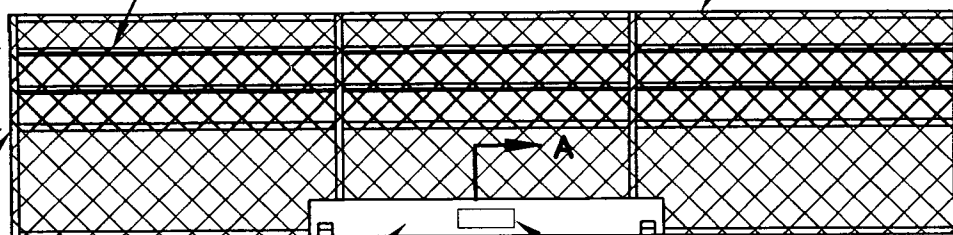
SECTION A-A (ROTATED 90° CCW)

FINISH THIS SECTION ALONG
ENTIRE LENGTH PER NOTE 3
AFTER POWDER COAT

TACK WELD MESH TO
FRAME AT EVERY AVAILABLE
LOCATION IN AREA TO BE
ANTI SKIDDED

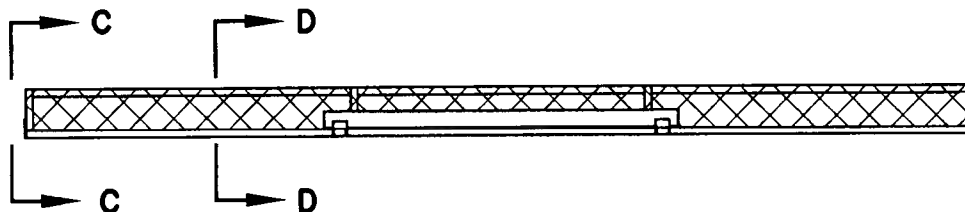
SKIN OUTSIDE SURFACE OF LID WITH
3/4-16F EXPANDED SS. TACK WELD
EACH END STRAND TO FRAME

SEE DETAIL B FOR
FRAME ASSEMBLY



D2506 LABEL PLATE
CENTER ON THE BASKET

REMOVE 2" X 6" SECTION
OF MESH FROM BEHIND
LABEL PLATE



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SUBJECT TO AMENDMENT
WITHOUT NOTICE

D3515-041 BASKET LID ASSEMBLY

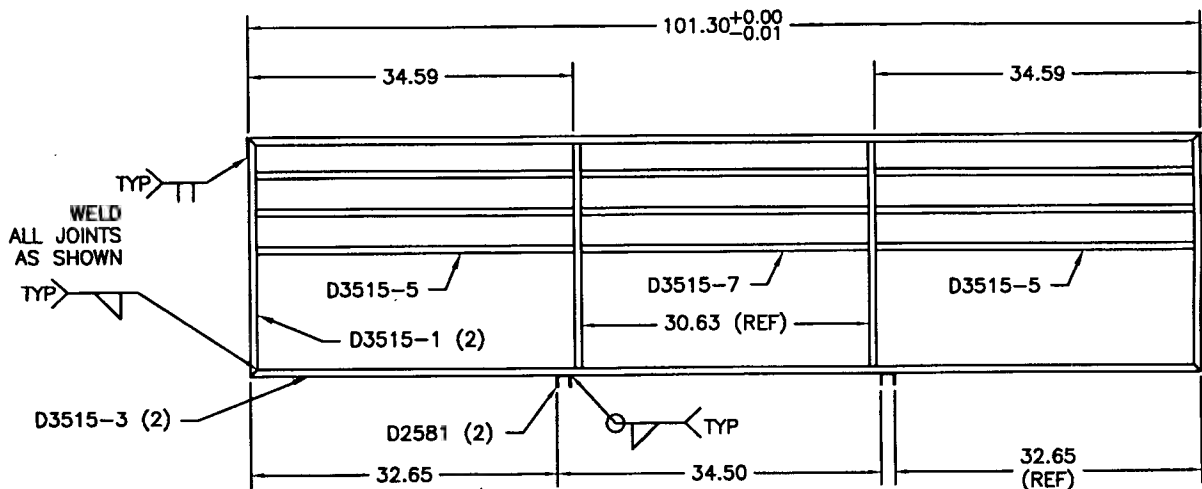
- 1) MESH MATERIAL: 3/4-16F EXPANDED SS (REF. DART SPEC. M304EX0.75-16F)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	TITLE	REV. A
06.05.05	BASKET LID ASSEMBLY (A119)	SHEET 2 OF 4
		SCALE 1:20



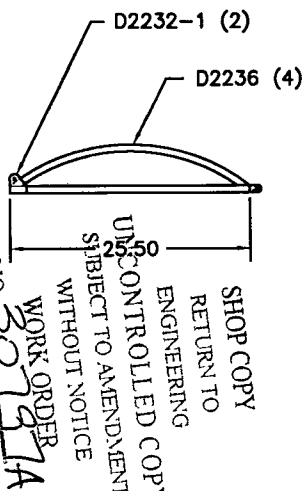
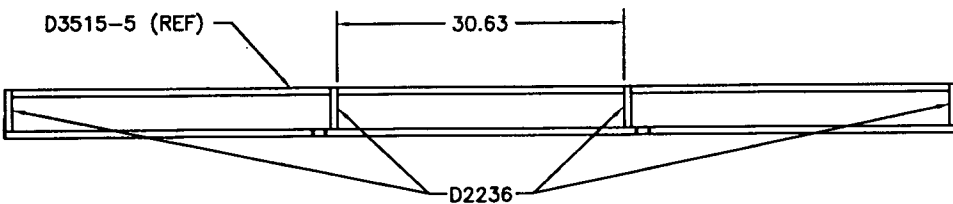
DART

DESIGN	BY	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE		D3515	SHEET 3 OF 4
06.05.05		TITLE	SCALE
		BASKET LID ASSEMBLY (A119)	1:20



DETAIL B

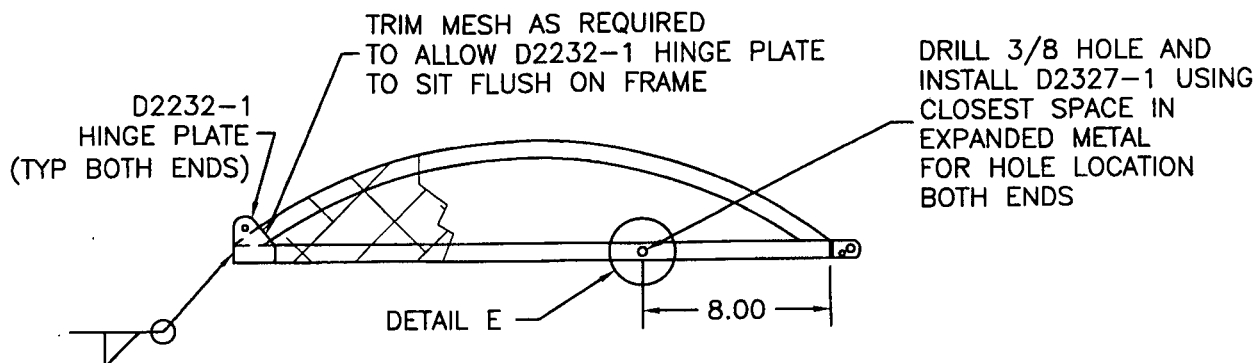
FRAMEWORK SHOWN FOR CLARITY
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES



RELEASED
06.11.17

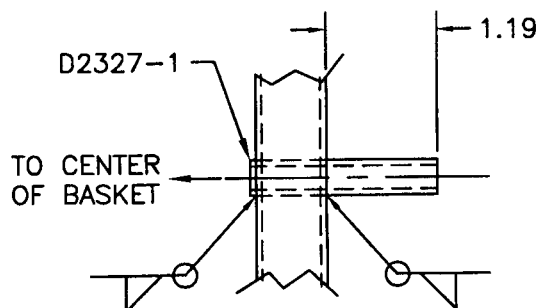


DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3515	REV. A SHEET 4 OF 4
DATE 06.05.05		TITLE BASKET LID ASSEMBLY (A119)	SCALE 1:8

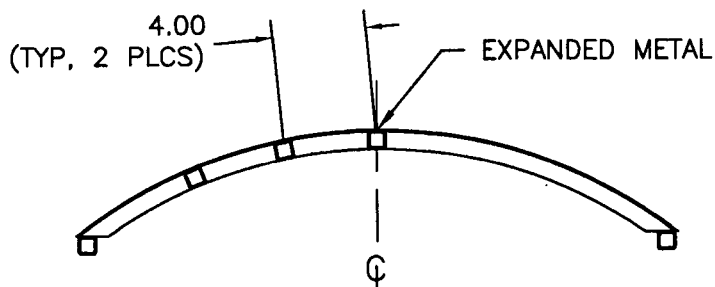


SECTION C-C SIMILAR BOTH END RIBS

RELEASED
06-11-17



DETAIL E



SECTION D-D SAME BOTH CENTER RIBS

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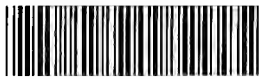
Date: Thursday, 2/22/2007 2:52:46 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET BASE ASS'Y (A119)
Job Number	: 30797B		
Estimate Number	: 12431		
P.O. Number	:	Part Number	: D3516041
This Issue	: 2/22/2007 S.O. No. :	Drawing Number	: D3516 REV.B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: B
Previous Run	: 29556B	Material	:
Written By	:	Due Date	: 3/30/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>JA 07.02.23</u>		
Comment	: EST rev. A 06.05.31 Preliminary EC EST rev. A 06.07.27 updated EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D34421	Shim
-----	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)



Shim

Batch: B33280

Pl 07.10.22

2.0	D2581	Mounting Bracket
-----	-------	------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)



Mounting Bracket

Batch: B34445

Pl 07.10.22

3.0	D351611	CLEVIS
-----	---------	--------



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)



CLEVIS

batch: B31800

Pl 07.10.22

4.0	D351613	CLEVIS
-----	---------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)



CLEVIS

batch: B31627

Pl 07.10.22

5.0	D23273	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)



Spacer Bushing

Batch: B33046

Pl 07.10.22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/22/2007 2:52:47 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASS'Y (A119)

Job Number: 30797B

Part Number: D3516041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D22323

Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

✓ Basket Hinge

Batch: B33290

Plot 10.22

7.0

D31661

Basket Hoop



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

✓ RIB

Batch: ~~B34673~~ B34673

Plot 10.22

8.0

M304TS0750W065

304 SQ Tube.75x.75x.065W



Comment: Qty.: 53.1825 f(s)/Unit Total : 53.1825 f(s)

✓ AISI 304 SQ Tube.75x.75x.065W

Batch: M105604

Plot 10.22

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut rib D3516-1 as per dwg D3516

2-Cut rib D3516-3 as per dwg D3516

3-Cut rib D3516-5 as per dwg D3516

4-Cut rib D3516-7 as per dwg D3516

5-Cut rib D3516-9 from D3166-1 (4)

Plot 10.22

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3516

Plot 10.22

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

E A 10/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/22/2007 2:52:47 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASS'Y (A119)

Job Number: 30797B

Part Number: D3516041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12 0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 60.0000 sf(s)/Unit Total : 60.0000 sf(s)
Expanded Metal Flat Stainless steel
Batch: M104218

P/102-10-24

13 0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut expanded metal for base as per dwg D3516

2-Cut expanded metal for base ends as per dwg D3516

3-Weld expanded metal to base as per dwg D3516

P/102-10-24

14 0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-10-26 (1)

15 0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 07-10-26 (1)

16 0

POWDER COATING

POWDER COATING



M 105068



(1x)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

m-l 07/10/27

17 0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3515 and QSI 005 4.4 and spay paint as per Dwg

Wing Walk: M106030

Black Spray Paint: M106028

m 07 10 28

18 0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M/07/10/29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/22/2007 2:52:47 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASS'Y (A119)

Job Number: 30797B

Part Number: D3516041

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

ml 07/10/09

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Don 07/11/09 ①

Job Completion



U 07.10.31

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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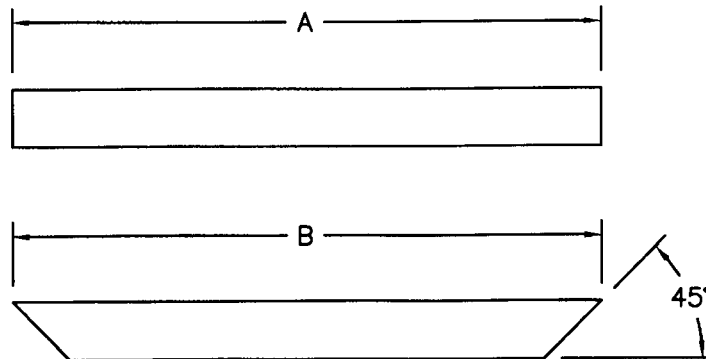
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3516	REV. B SHEET 1 OF 5
DATE 06.07.25		TITLE BASKET BASE ASSEMBLY (A119)	SCALE NTS
A	06.06.21	NEW ISSUE	
B	06.07.25	ADD (4) D3516-13, (6) D3516-11 WAS (10), SEE TR-D119-756-1 REV. A	

RELEASED

06.11.28 *[Signature]***PARTS LIST FOR D3516-041 BASKET BASE ASSEMBLY**

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3516-1	2	—	102.00	RIB
D3516-3	2	—	25.50	RIB
D3516-5	8	26.75	—	RIB
D3516-7	3	45.50	—	RIB
D3516-9	4	N/A	N/A	RIB
D3516-11	6	N/A	N/A	CLEVIS
D3516-13	4	N/A	N/A	CLEVIS
D2232-3	2	N/A	N/A	HINGE PLATE
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRKT
D3442-1	2	N/A	N/A	SHIM

B {

**NOTES:**

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) FRAME MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
(REF. DART SPEC. M304TS0.750W.065)
- 3) MESH MATERIAL: 3/4-16F EXPANDED SS
(REF. DART SPEC. M304EX0.75-16F)
- 4) WELD PER DART QSI 004
- 5) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

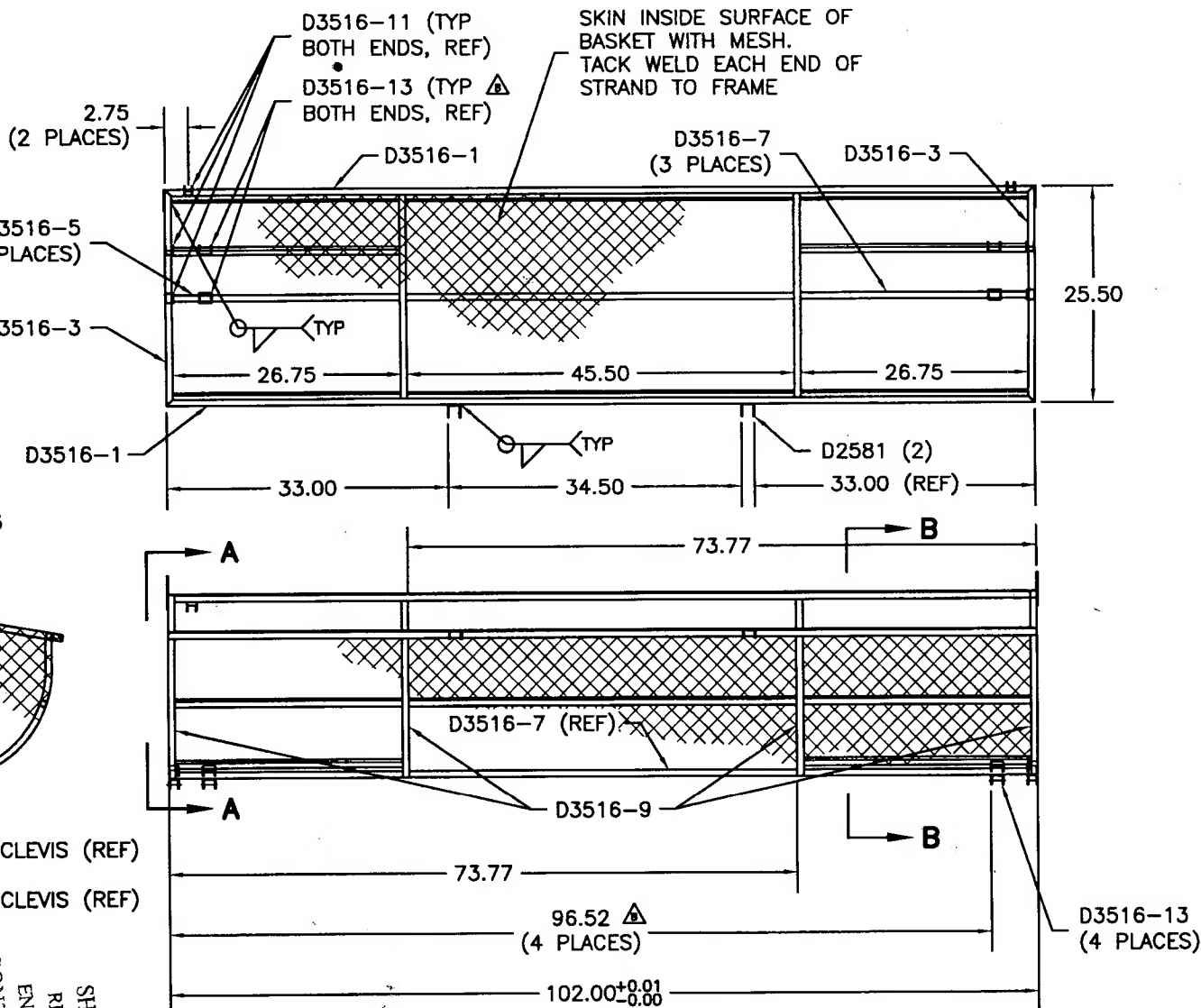
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		DRAWING NO.	D3516
		REV. B	SHEET 2 OF 5
		SCALE	1:20



D3516-041 BASKET BASE ASSEMBLY

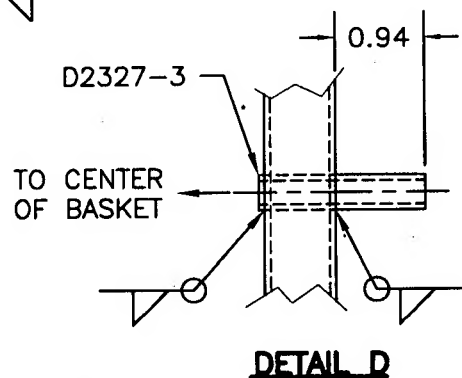
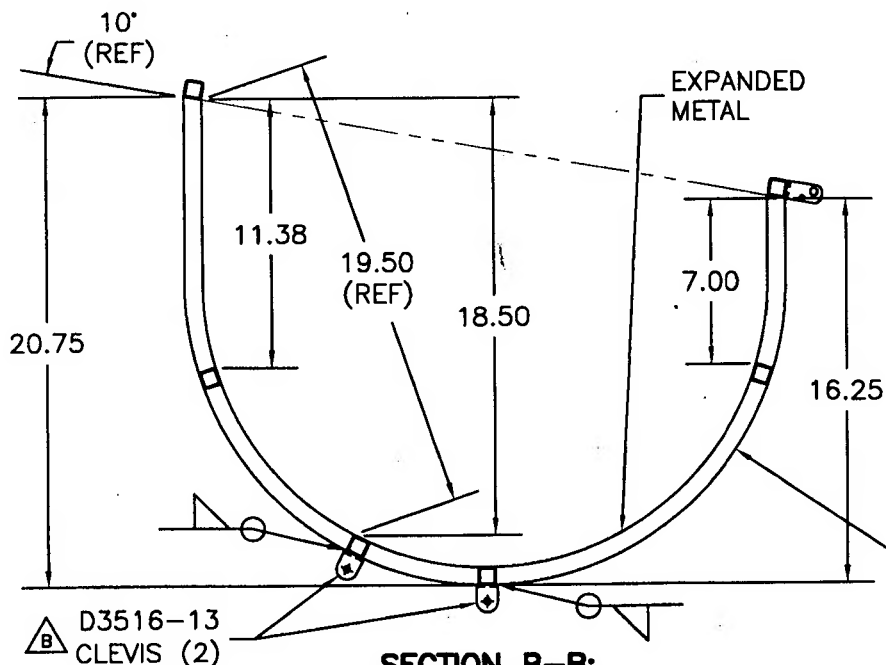
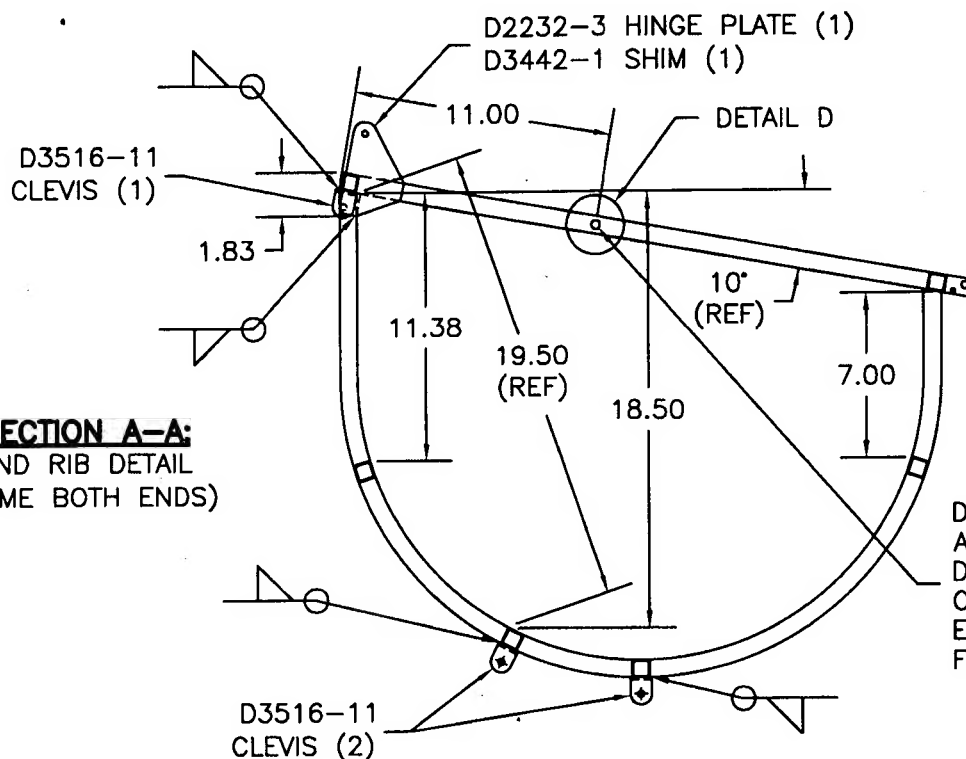
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DATE 06.07.25	TITLE BASKET BASE ASSEMBLY (A119)		SCALE 1:8

SECTION A-A:
END RIB DETAIL
(SAME BOTH ENDS)

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(MAKE FROM D2235-3)
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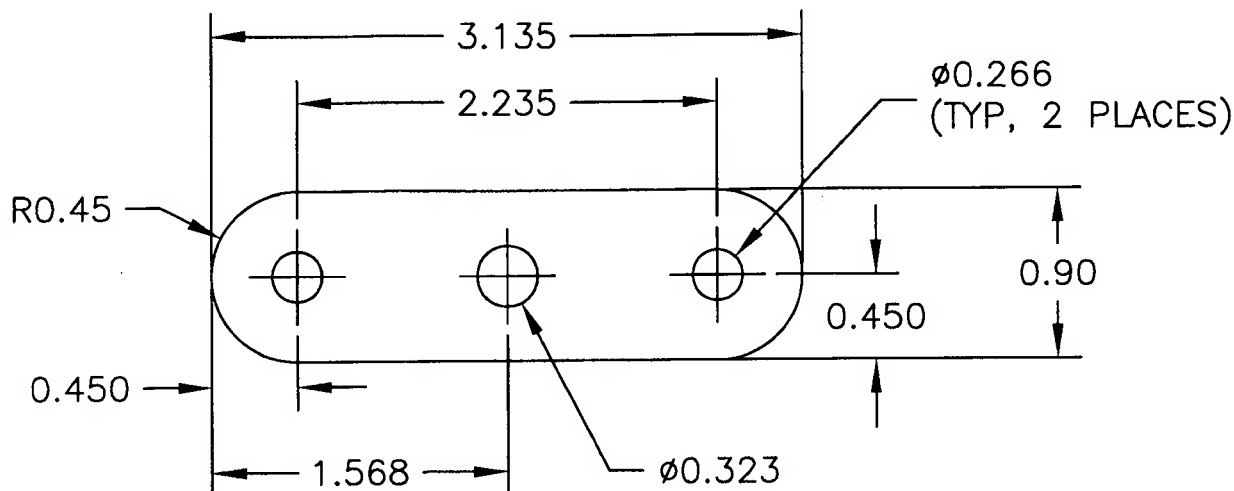
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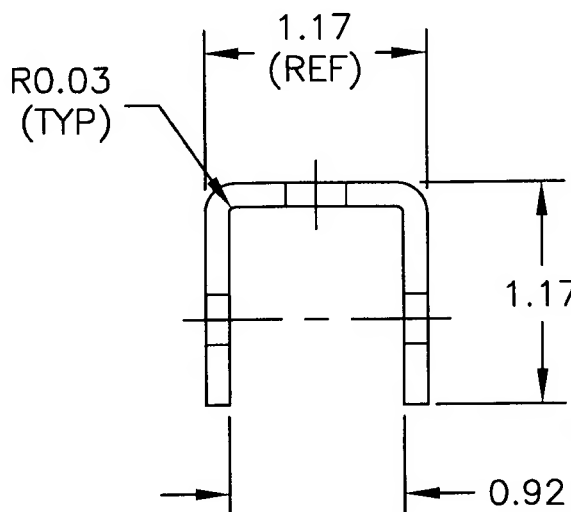
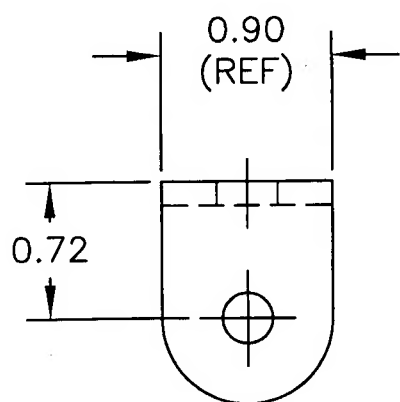
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DATE 06.07.25		TITLE BASKET BASE ASSEMBLY (A119)	SCALE 1:1

**D3516-11F CLEVIS FLAT PATTERN**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)

RELEASED

06.11.28 *[Signature]***D3516-11 CLEVIS BENDING DETAIL**

- 1) MATERIAL: MAKE FROM D3516-11F
2) ALL DIMENSIONS ARE IN INCHES
3) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

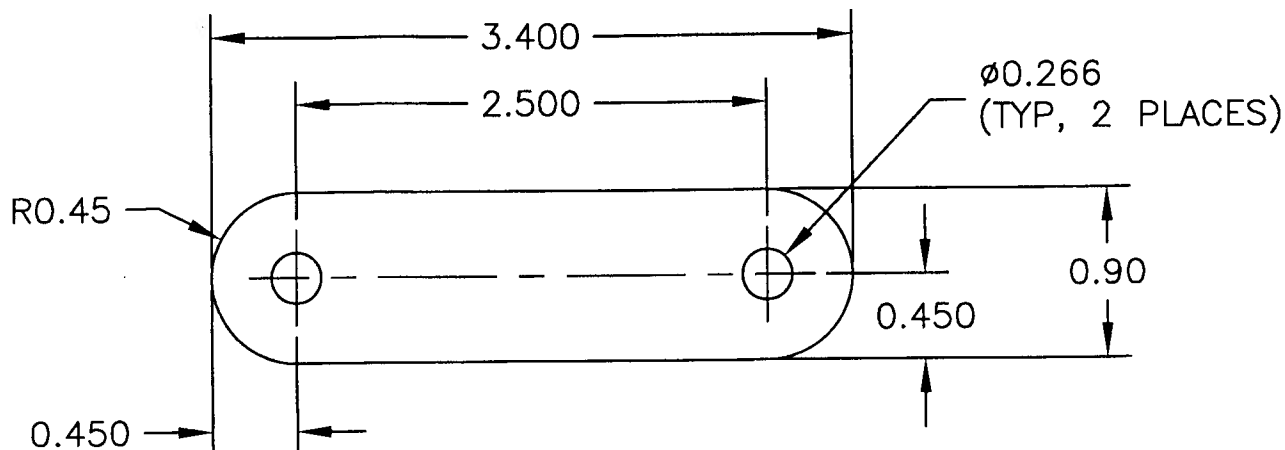
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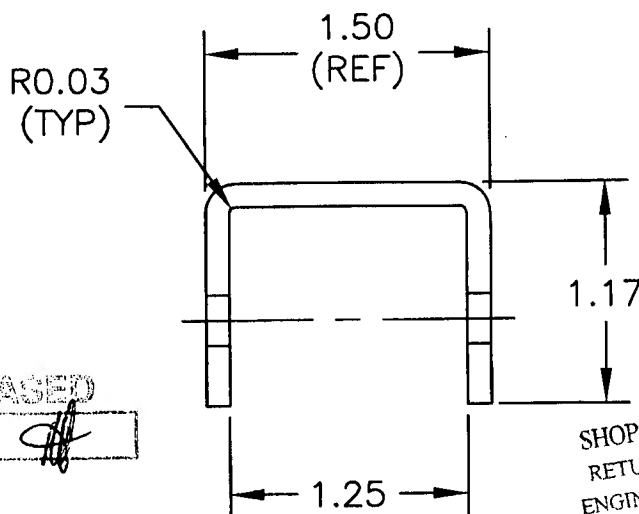
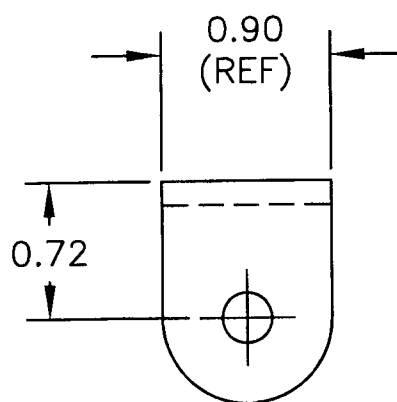


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DATE 06.07.25		TITLE BASKET BASE ASSEMBLY (A119)	SCALE 1:1



D3516-13F CLEVIS FLAT PATTERN

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)



D3516-13 CLEVIS BENDING DETAIL

- 1) MATERIAL: MAKE FROM D3516-13F
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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